

MONDAY 12/08

Dart Aerospace Ltd.

Date: Friday, 05/12/2008 9:18:24 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	43923		
<b>Estimate Number</b> :	13055		
<b>P.O. Number</b> :		<b>Part Number</b> :	D36541
<b>This Issue</b> :	05/12/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3654 REV.B
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39927	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	08/12/2008
<b>Written By</b> :			<b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 07-10-29 DD verified by: EC Est Rev:B ecn1162 08-04-02 DD verified by:ec Est Rev:C 08-09-17 revB as per dwg DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.3675 sf(s)/Unit Total : 1.4700 sf(s)  
 304/316 SS sheet 16 ga (0.063" thick)  
 Batch: 109057 IB 8-12-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3654  
 Dwg Rev: B IB 8-12-8  
 Prog Rev: B  
 2-Deburr if necessary IB 8-12-8

(S)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/12/08 VS

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and stock  
 Location: ST 182

508/12/08 VS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/12/2008 9:18:24 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43923

Part Number: D36541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 43923
<b>Description:</b> Double	<b>Part Number:</b> D3654-1
<b>Inspection Dwg:</b> D3654-1, <b>Rev:</b> B	<b>Page 1 of 1</b>


## FIRST ARTICLE INSPECTION CHECKLIST

**x First Article**

<b>x</b>	<b>Prototype</b>
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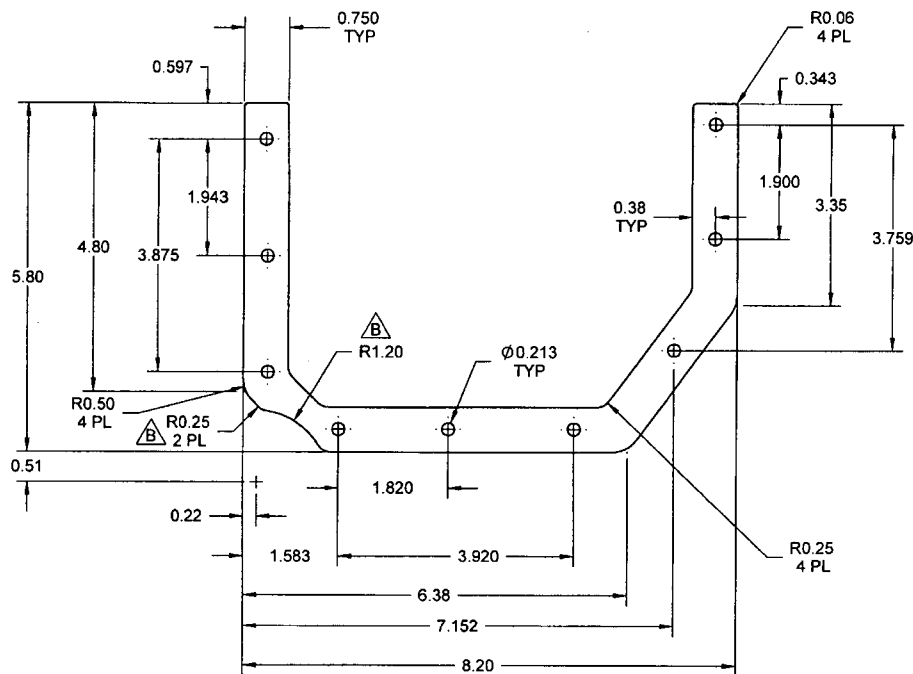
[illegible]

Measured by:	HB
Date:	8-12-8

<b>Audited by:</b>	
<b>Date:</b>	6/6/12/08

<b>Prototype Approval:</b>	<i>n</i>
<b>Date:</b>	<i>9</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3654-1 DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

**RELEASED**  
08-09-11

B	ADD R1.20 & R0.25 (ZN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5019 (ZN A6); REFORMATTED DRAWING TO CURRENT STANDARD	RF	08.09.11
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3654</b>	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLER</b>	NTS
DATE	08.09.11	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	